

Ship 18/05

Dart Aerospace Ltd.

Date: Friday, 5/11/2007 12:55:13 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP BRACKET
Job Number	: 32326		
Estimate Number	: 10842		
P.O. Number	: N/A	Part Number	: AS3509260
This Issue	: 5/11/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: AS350-9201
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24727	Drawing Revision	: N/A
		Material	: N/A
Written By	: [Signature]	Due Date	: 5/18/2007
Checked & Approved By	: [Signature] 07.05.11	Qty:	4 Um: Each
Comment	: Est Rev: A New Issue 05-11-21 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 AS3509265 Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
4	AS3509265	LUG	B31557/17629

FC 07 05 17

(4)

2.0 AS3509268



AS350 92 63
AS 350 92 62

Half Bracket Qty: 16
B31557/17629
Qty: 4
B31557/17629

FC 07/05/17
FC 07/05/17

(4)

Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
8	AS3509268	Bracket	

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg AS350-9201 using Eagle Welding Jig

A/R 4130 Welding Rod

Batch: M102226

FC 07/05/17 (4)

4.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

07/05/17 (4)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07.05.18 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

Friday, 5/11/2007 12:55:13 PM

Kim Johnston

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Drawing Name: STEP BRACKET

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Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SD 07/05/18

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

8.0

AN416A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part#
16 AN4-16a

Description
Bolt

Batch
M18949

SD 07/05/18

9.0

AN960416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 128.0000 Each(s)

Pick:

Qty Part#
32 AN960-416

Description
Washer

Batch
M5519

10.0

NAS1334C6C14D

PIP PIN



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part#
4 NAS1334C6C14D

Description
Pip-Pin

Batch
M19393

7/5/18 SD

11.0

MS20365428

NUT



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part#
16 MS20365-428

Description
Nut

Batch
M17975

12.0

D34369

Pad



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part#
8 D3436-9

Description
Pad

Batch
B23359

SD 07/05/18

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble Pads using Contact Cement

A/R Contact Cement Batch: M102565

2-Assemble

SB 07/05/18

(4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/18

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/18 SB

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07/05/18

Job Completion



07/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries